

delrin 010

Work Order ID 133935

133935

Page 1

Tuesday, June 23, 2015 3:24:44 PM

Item ID: D2374

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stud

Start Date: 6/23/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/23/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: JUN 24 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2374

Rev A

100

0.00

100

Doosan

DOOSAN LATHE

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA156 Rev: AA & Dwg D2374 Rev: A 2- Mill
as per Folio FA156 Rev: AA & Dwg D2374 Rev: A 3-Deburr per
dwg D2374

14 0 JH 2015-06-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

14 0 JH 2015-06-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

14 0 JH 2015-06-28
15/06/30

DAS
14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 133935***133935***

Page 2

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Item Name: Stud

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST 006

0.00

130

Packaging

Memo

0.00

14

J.A

JUL 06 2015

DAS
6
8.89

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

MLJ

JUL 07 2015

Quality Control

MLJ JUL 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, June 23, 2015 3:24:44 PM

Page 1

Work Order ID: 133935

133935

Parent Item: D2374

D2374

Parent Item Name: Stud

Start Date: 6/23/15

Required Date: 6/23/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP D03.04.04Reformat; Made on CobraKJ/RF
IPP Rev:E Now on Doosan Lathe 08-05-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.000		Purchased			No	100	f	15.0400	0.1271	2			

MDFI RINR1 000

Delrin Round Bar 1" color: black

Location

Loc Qty

Loc Code

MAT039

15.04

→ m130188

15.04

24 JFC 2015-06-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

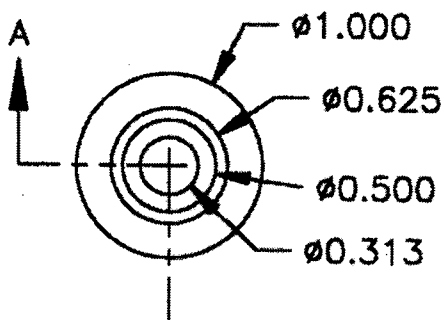
QA Closed: _____ Date: _____

Work Order update only ☐

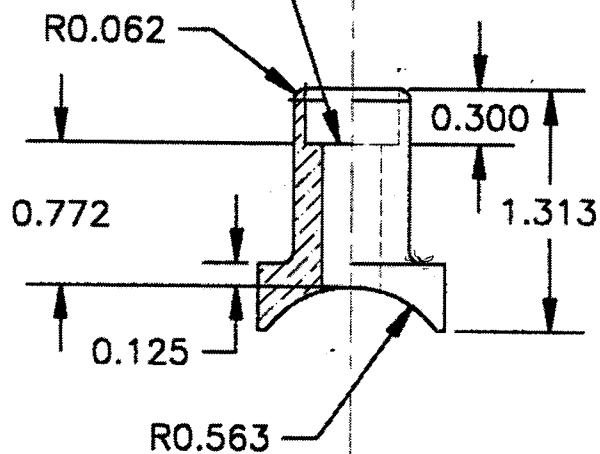
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO. D2374	REV. A
CHECKED Bw	APPROVED 		SHEET 1 OF 1
DATE 95:02:24	TITLE STUD 1:1		



COUNTER BORE
Ø0.500 X 0.300 DEEP
Ø0.313 THROUGH



SECTION A

MATERIAL: DELRIN BLACK

SHOP COPY
REF TO
ENGINEERING
UNCONTROLLED COPY
NOT FOR CONSTRUCTION
WITHOUT NOTICE
WORK ORDER
NO. 133935.MC5

1506-24